

Work Order ID 154064

Thursday, December 01, 2016 10:20:07 AM

154064

Page 1

Item ID: D3018-1 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Seat Cushion
Start Date: 12/30/2016 Start Qty: 2.00 ***2*** Cust Item ID:
Required Date: 1/9/2017 Req'd Qty: 2.00 ***2*** Customer:
Reference:

Approvals: Process Plan: DAS 21 Date: DEC 01 2016 Tooling: _____ Date: _____ Run Start ***NR1***
QC: 9-89 Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3018	B								

100

0.00

100

Purchasing

PURCHASING

Memo

0.00

Purchasing

Issue P/O: 34531

Possible supplier: Chestnut Ridge Airflex fire-resistant aircraft cushioning

Order: Grade 55.65 (colour orange), Density 3.6lb/ft³

Material must meet FAR 27.853(a) or 25.853(a)

Part is symmetric about centerline-All dimensions

2 DEC 05 2016DAS
13
9-89

110

0.00

110

Packaging

Packaging

Memo

0.00

Packaging

Ensure Material Release Note is attached

2x SP/6-12-22

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																											
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval																																																							
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval																																																							
Root Cause		FAULT CATEGORY																																																													
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER :	
Misidentified ☐	Past Due ☐																																																														

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Item ID: D3018-1 Accept

*N900040100

Revision ID:

Item Name: Seat Cushion

Start Date: 12/30/2016 Start Qty: 2.00 *2*

Cust Item ID:

Required Date: 1/9/2017 Req'd Qty: 2.00 *2*

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code
--------------------------------	--------------------------	----------------------	---------	--------	--------------

120

QC6- Inspect dimensions to drawing

0.00

120

QC

Quality Control

Memo

0.00

*****REMOVE "CHESTNUT FOAM" LABEL AND ATTACH TO WORK
ORDER FOR TRACEABILITY*****

130

Identify as per dwg & Stock Location: ST 415 0.00

130

Packaging

Packaging

Memo

0.00

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Quality Control

Memo

0.03

SO#: 56847
DATE MFD: 01/17



CHESTNUT RIDGE FOAM, INC.
443 WAREHOUSE DR.
LATROBE, PA 15650
P/N: 502148-99

DAS
9
9-89

② 16-1222

2X SP17-01-20

DAS
21
9-89

JAN 24 2017

MF

17-1-20

DQA: _____ Date: _____

QA Closed: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging Supplier ☐ Engineering Quality ☐ Other ☐					
Date : _____		Step #: _____		QTY Effective : _____			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition					
200 e 88-6							Completed By		
							Lead hand / Supervisor Approval Verification		
							QC / QA Coordinator Approval		
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
OTHER : _____									

Thursday, December 01, 2016 10:20:07 AM

Page 1

154064

D3018-1

Required Date: 1/9/2017

Required Qty: 2.00

Comments: IPP: B01.06.08Removed acid etch & alodine EC
11.08.08 added note per NCR 11-588 DD VERF:EC IPP REV:C

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D3018-1P	Purchased	No
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D3018-1P

Seat Cushion

2x SP/6-12-22

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



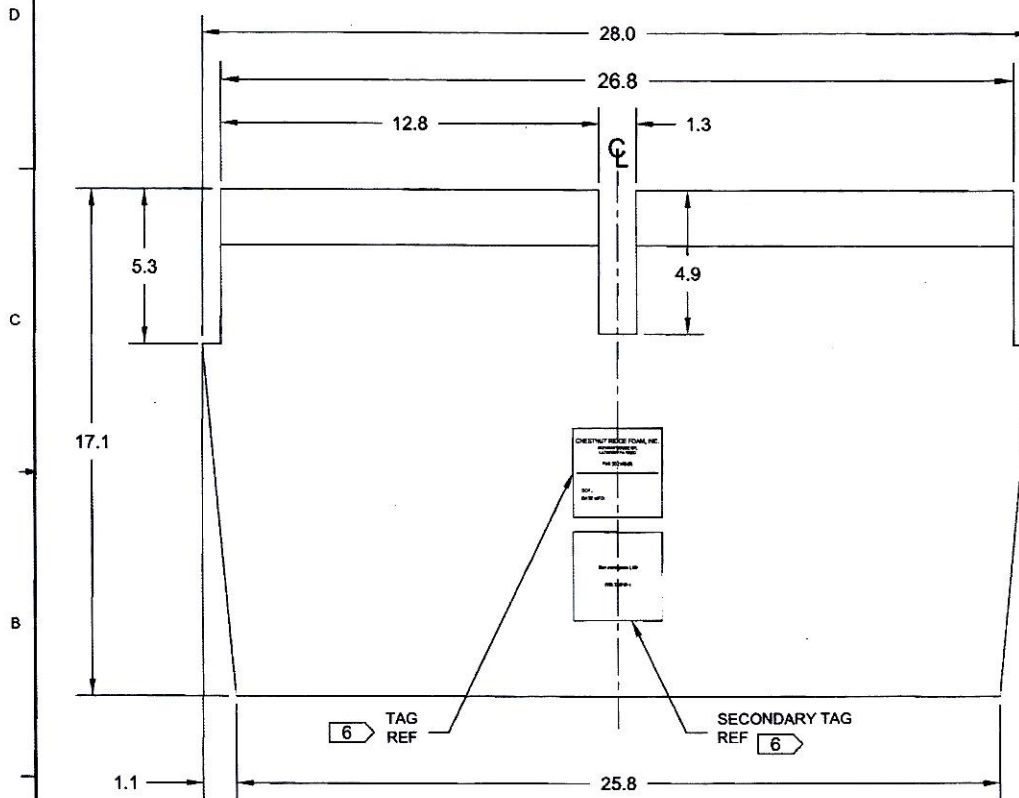
QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
		OTHER : ☐							

SPECIFICATION CONTROL DRAWING

THICKNESS/ HEIGHT	TOLERANCE		LENGTH/ DEPTH	TOLERANCE		WIDTH (LEFT TO RIGHT)	TOLERANCE	
	(+)	(-)		(+)	(-)		(+)	(-)
0.0 - 0.50	0.06	0.06	0.00 - 0.63	0.06	0.06	0.00 - 0.63	0.06	0.06
0.51 - 1.00	0.13	0.06	6.01 - 12.00	0.13	0.13	6.01 - 12.00	0.13	0.13
1.01 - 3.00	0.13	0.06	12.01 - 24.00	0.25	0.25	12.01 - 24.00	0.25	0.25
3.01 +	0.19	0.13	24.01 +	0.50	0.38	24.01 +	0.50	0.38

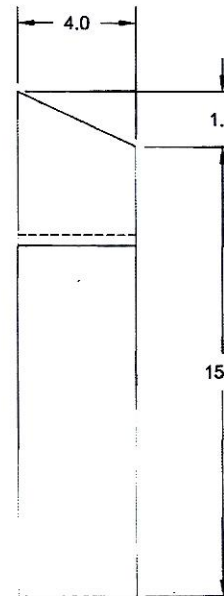


D3018-1 SEAT CUSHION

NOTES:

- 1) MATERIAL: MUST MEET FAR 27.853(a) OR 25.853(a)
AIRFLEX FIRE-RESISTANT AIRCRAFT CUSHIONING
GRADE 55-65 (COLOUR ORANGE)
DENSITY 3.6 lb/ft³
- 2) FINISH: NONE
- 3) TOLERANCES: PER TABLE 1
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A

- 6) IDENTIFICATION: TAG(S), BURNED, TO SHOW THE FOLLOWING AT MINIMUM:
CHESTNUT RIDGE FOAM, INC.
443 WAREHOUSE DR.
LATROBE, PA 15650
SO#
DATE MFD:
DART AEROSPACE LTD. P/N D3018-1
- 7) PART IS SYMMETRICAL ABOUT CENTERLINE
- 8) MAKE PER TEMPLATE
- 9) POSSIBLE SUPPLIER: CHESTNUT RIDGE P/N 502148-99



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 154064 MS
16-12-01

RELEASED
2011-05-12

B	UPDATE TO CURRENT STD; DRAWING REVISED IAW CHESTNUT RIDGE MFG DWG. REF: NCR11-588	MB	11.05.10
A	NEW ISSUE	CP	01.05.18
REV.	DESCRIPTION	BY	DATE
DESIGN	19	DART AEROSPACE LTD	
DRAWN	19	HAWKESBURY, ONTARIO, CANADA	
CHECKED	19	DRAWING NO.	REV. B
MFG. APPR.	19	D3018	SHEET 1 OF 1
APPROVED	19	TITLE	SCALE
DE APPR.	19	SEAT CUSHION	NTS
DATE	11.05.10	COPYRIGHT © 2001 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CORONATION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO34531**

Purchase Order Date 12/5/2016 12:57:43 PM

PO Print Date 12/5/2016

Page Number 1 of 2

Order From :
CHESTNUT RIDGE FOAM, INC.
PO BOX 6015
HERMITAGE, PA 16148
US

VU-CHE001

Ship To : DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

DEC 05 2016

E-MAILED

Contact Name		Buyer	Chantal Lavoie
Vendor Phone	724 537 9000	Customer POID	
		Customer Tax #	10127-2607
Ship To Contact		Terms	Net 30
Ship To Phone		Currency	USD
Ship Via:	FedEx Overnight collect	FOB	Destination-Collect
Ship Acct:			

Line Nbr	Reference Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
	Line Comments		Promise Date				
	Delivery Comments						
1	D3018-1P	Seat Cushion	12/19/2016		2.00	\$60.40	\$120.80
			Yes		Each		
			12/19/2016				
	AS PER DWG D3018 REV. B B154064						
						Line Total:	\$120.80
3	71401-45	PROCUREMENT QUALITY CLAUSES	12/19/2016		1.00	\$0.00	\$0.00
			No				
			12/19/2016				
	Procurement Quality Clauses						
	A004 faa-pma/tso						
	A005 right of entry						
	A016 personnel qualification						
	A026 certification of material conformance						
	A027 flammability test						
	A040 notification of quality escape						
	A042 dart notification by supplier						
	A043 retention of quality document						

Note:

12/5/2016

Chestnut Ridge Foam, Inc.
443 Warehouse Drive
P.O. Box 781
Latrobe PA 15650

Phone: 724-537-9000
Fax: 724-537-9003



Pack Slip: 69241

Packing Slip

Page: 1 of 1

Ship To: Fed Exp #1517-9324-0
Dart Aerospace Ltd.
1270 Aberdeen Street
Tel: 613-632-3336
Hawkesbury ON K6A 1K7
Canada

Phone: 613-632-3336
Fax: 613-632-1053

Sold To: Chantal Lavoie Fax#: 613-632-1053
Dart Aerospace Ltd.
1270 Aberdeen Street
Tel: 613-632-3336
Hawkesbury ON K6A 1K7
Canada

Phone: 613-632-3336
Fax: 613-632-1053

Ship Date: 12/19/2016
Ship Via: Fed Exp Int P1

F.O.B.: Origin

PO Line	Part Number/Description Planned Qty	Shipped Qty	Rev	PO Line
---------	--	-------------	-----	---------

Sales Order: 56847

Your PO: PO34531

Salesperson: Matt Gurgio

*Certificate of Conformity that all components comply with 14CFR 25.853(a) 12 Second Vertical Burn with Shipment
The following Quality Clause Codes apply to this order: A004, A005, A016, A026, A027, A040, A042, and A043.*

Line 1

Rel 1

D3018-1P ✓

AIRFLEX Bottom Cushion
2.00 EA ✓

2.00 EA

Our Part: 502148-99

Sp/6-12-22

CONTACT CHESTNUT RIDGE FOAM IF THERE IS DAMAGE OR DISCREPANCIES 724-537-9000



Certificate of Conformance

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury
Ontario CANADA K6A 1K7

PURCHASE ORDER: PO34531

SALES ORDER: 56847

DATE SHIPPED: 12/19/2016

I certify that the individual components comprising the part(s) shipped against the above-referenced purchase order meets:

14 CFR 25.853(a), APPENDIX F, PART 1(a)(1)(ii), AMENDMENT 25-116

Quantity	Customer Part Number	CRF Part Number	Material	Batch Number
2	D3018-1P	502148-99	CR AIRFLEX 55-65	AF16030
		DAS 9 9-89		

MADE IN THE U.S.A

Robin Meighen

Digitally signed by Robin Meighen
DN: cn=Robin Meighen, o=Chestnut Ridge
Foam, Inc., ou=Sr. Q.A. Inspector,
email=rmeighen@chestnutridgefoam.com, c=US
Date: 2016.12.19 07:35:48 -05'00'

❖ 443 Warehouse Drive Latrobe, PA 15650
❖ Phone: 724-537-9000 Fax: 724-537-9003

CHESTNUT RIDGE FOAM INC.
VERTICAL BURN TEST # 16171
12-SECOND VERTICAL BUNSEN BURNER TEST
FOR CABIN AND CARGO COMPARTMENT MATERIALS
SHOWING COMPLIANCE TO THE REQUIREMENTS OF 14 CFR 25.853

PRODUCT : CR AIRFLEX
BATCH / LOT NO : AF16030
CUSTOMER : PRODUCTION
P.O. NO :
OTHER IDENTIFICATION : CR AIRFLEX 55-65, 1/2 inch thickness
CRF P/N:

TEST BEING RUN : VERTICAL BUNSEN BURNER TEST: 12 SECOND IGNITION TIME
MEETS REQUIRED MINIMUM FLAME TEMPERATURE OF 1550°F : YES

MATERIAL COMPOSITION : AIRFLEX

MATERIAL PATTERN : NA

MATERIAL COLOR : ORANGE

CONDITIONING STARTED : DATE : 8-18-16
TIME : 2:30 PM

TEST STARTED : DATE : 8-22-16
TIME : 12:30 PM

RESULTS :

	FLAME TIME (SECONDS)	DRIPPINGS (SECONDS)	BURN LENGTH (INCHES)
#1.	0.0	0.0	4.1
#2.	0.0	0.0	4.0
#3.	0.0	0.0	4.1
AVG.	0.0	0.0	4.1

PASS : X FAIL :

COMMENTS :

THIS MATERIAL MEETS THE REQUIREMENTS OF THE 14 CFR, PART 25, SECTION 25.853,
PARAGRAPH (a) AND APPENDIX F, PART 1, (a), (1), (ii).

TESTED BY : Kelly Bures
Laboratory Technician



CHESTNUT RIDGE FOAM INC.
VERTICAL BURN TEST # 16200
12-SECOND VERTICAL BUNSEN BURNER TEST
FOR CABIN AND CARGO COMPARTMENT MATERIALS
SHOWING COMPLIANCE TO THE REQUIREMENTS OF 14 CFR 25.853

PRODUCT: TICKING FR 4440 FABRIC
 BATCH/LOT NO: 2308
 CUSTOMER: PRODUCTION
 P.O. NO: 36239
 OTHER IDENTIFICATION:

TEST BEING RUN: VERTICAL BUNSEN BURNER TEST 12 SECOND IGNITION TIME

MEETS REQUIRED MINIMUM FLAME TEMPERATURE OF 1550°F: YES

MATERIAL COMPOSITION: NA

MATERIAL PATTERN: WOVEN

MATERIAL COLOR: TAN

CONDITIONING STARTED: DATE 9-27-15
 TIME 11:30 AM

TEST STARTED: DATE 9-29-15
 TIME 10:25 AM

RESULTS

	FLAME TIME (SECONDS)		DRIPPINGS (SECONDS)		BURN LENGTH (INCHES)	
	WARP	FILL	WARP	FILL	WARP	FILL
#1	00	00	00	00	4.3	4.1
#2	00	00	00	00	4.3	4.3
#3	00	00	00	00	4.1	4.3
AVG.	00	00	00	00	4.2	4.2

PASS: X FAIL:

COMMENTS

THIS MATERIAL MEETS THE REQUIREMENTS OF THE 14 CFR, PART 25, SECTION 25.853, PARAGRAPH (a) AND APPENDIX F, PART 1, (a), (1), (ii)

TESTED BY: Kelly Bures
 Laboratory Technician

Kelly Bures

INVOICE HANES ENGINEERED MATERIALS L&P FINANCIAL SERVICES CO. P.O. BOX 60984 CHARLOTTE, NC 28260			
CORPORATE OFFICE: 500 N. McLin Creek Rd. P.O. BOX 457 CONOVER, NC 28613-0457 PHONE (828) 464-4673 FAX (828) 464-0459			
SOLD TO CHESTNUT RIDGE FOAM ROUTE 981 NORTH PO BOX 781 LA TROBE, PA 15650		SHIP TO CHESTNUT RIDGE FOAM 443 WAREHOUSE DRIVE LA TROBE, PA 15650	
INVOICE NUMBER 62 176755	INVOICE DATE 9/23/2016	TERMS NET 30	CARRIER USF HOLLAND INC
CUSTOMER NO. 15985	CUSTOMER ORDER NO. 36239	SLS MONTH/SEMI 65 452	ORDER DATE 9/20/2016
CONOVER, NC		PER ANNETTE 8/21/14	
DAY 8		S/L 33157	RELEASE # 010 30828
QUANTITY 40.000	DESCRIPTION TICKING FR 4440	PRICE 250.00	AMOUNT 10000.00
CERTIFICATION: THE SELLER DOES NOT CERTIFY, EITHER IMPLICITLY OR EXPLICITLY, THESE PRODUCTS TO MEET THE REQUIREMENTS OF ANY REGULATORY AGENCY OR SPECIFICATION EXCEPT AS MAY BE CERTIFIED ABOVE OR UNDER SEPARATE WRITTEN CERTIFICATION. ALL TRANSACTIONS ARE SUBJECT TO THE CONDITIONS ON THE REVERSE SIDE OF THIS INVOICE.			
USF HOLLAND INC. PHONE 10533783066			
OCT 04 2016			

15985

ORIGINAL

847

THIS INVOICE IS THE PROPERTY OF THE SELLER. IT IS TO BE USED ONLY FOR RECORDING PURPOSES. IT IS NOT TO BE USED FOR ANY OTHER PURPOSE. IT IS TO BE KEPT FOR A PERIOD OF 12 MONTHS FROM THE DATE OF INVOICE. IT IS TO BE KEPT IN A SAFE PLACE. IT IS TO BE KEPT IN A SAFE PLACE. IT IS TO BE KEPT IN A SAFE PLACE.

TOTAL INVOICE
AMOUNT

PAGE 1 LAST 42579